Work Order ID 84389 (1) May-11-12 8:16:54 AM		*843	889*			Page 1
Item ID: D3473-1 Revision ID: Item Name: Duct		Accept	*N900040	1100 *	Setup Sta	ומיאו
Start Date: 11/05/2012 Start Qty: 2.0 Required Date: 25/05/2012 Req'd Qty: 2.0 Reference:	***		Cust Item ID: Customer:		,	
Approvals: Process Plan: MCJ	Date: 17/05///	Tooling: _	Date:		Run Sta	"NR1"
QC:	Date:	SPC (Y/N):	Date:		Sto	" *NR2*
Sequence ID/ Operation Work Center ID Description		Set Up/ Run Hours	Tool ID Tool	# Plan Acc		Reject Insp. Number Stamp
Draw Nbr Revision Nbr				9 6		
D3473 Rev C				\		
*100 * FLOW WATER JET Waterjet	per Dwg D3473	0.00				B12-6-27
110 QC Memo	ff machine FAI/FAIB	0.00	Scrap will outsauced for w	on nut		1812-6-27
Quality Comrol			outsuit u	14.01.22		
120 QC8- Inspect parts - *120*	second check	0.00 Stock		4	6)	
QC Memo Quality Control		0.00				

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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	·	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	on:	_ QA: N/C C	losed:		Date: _	
NCR:		V	VORK ORD	ER NON-CONFORM	ANCE (NCI	R)			
DATE	STEP	Description of NC			tion B	Verific	cation	Approval	Approval
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
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Part No	:	PAR #:	Fault Cated	jory:	NCR: Yes	No DQ	A :	_ Date: _	,
	Re	Resolution: Disposition:				Closed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Section	on B Sign		cation	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Date		ion C	Chief Eng	QC Inspector
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Work Order ID 84389 May-11-12 8:16:54 AM			*843	389*						Page 3	
Item ID: Revision ID: Item Name:	D3473-1			Accept	*N900	<u>040</u>	100) * s	-		S1* S2*
Start Date: Required Date Reference:	11/05/2012	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item l Customer:	iD:				IV	5/
Approvals:	Process Pla	an:	Date:	Tooling:	D	ate:	-	F	Run St	art *N	R1*
	QC:	HL.	Date:	SPC (Y/N):	D	ate:			St	^{top} *N	R2*
Sequence ID/ Work Center 160	lD	Operation Description Identify as per dwg & St	ock Location:	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Packaging Packaging		Memo		0.00							
170		QC21- Final Inspection -	· Work Order Release	0.00							
170 QC Quality Control		Memo		0.00							

W14,01-23

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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	jory:	_ NCR: Yes	No DQ	A:	_ Date: _	
	Re	solution:	Disposition): <u>'</u>	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
	0750	Description of NC			on B	Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	Sect		Chief Eng	QC Inspector
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				·					

Picklist Print

May-11-12 8:16:58 AM Work Order ID: 84389

84389

Parent Item:

D3473-1

D3473-1

Parent Item Name: Duct

Start Date: 11/05/2012

Required Date: 25/05/2012

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A

New Issue 06-03-02 JLM

IPP Rev:B As per Rev B 06-05-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		rimary ocation	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA		Purchased	No			100	sf	91.8000	0.6005	1.264211	(6)	4,	
M304S26	GA								**		•	RI7.	-6-27

304/316 0.018 SHEET

Loc Code Location Loc Qty MAT020 91.8 117798 91.8

117798

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W/O:			WC	RK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	Re	solution:	Dispositio	າ: ່	QA: N/C C	losed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NC	R)			
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti		Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	84389
Description: Duct	Part Number:	D3473-1
Inspection Dwg: D3473 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
19.20520	+/-0.010	19.520	5		TBU	
4.500	+/-0.010	4,499	ĺ		V BUZ	
3.808	+/-0.010	3.808	,		V	
4.600	+/-0.010	4,600	2		V	
2.250	+/-0.010	ふつらう	3		1/	
1.930	+/=0.010	1.934	7-		V	-
2.341	+/-0.010	2.347	2		٧	
2.040	+/-0.010	770.G	2		٧	
2.416	+/-0.010	2,425	2		7	
	1-1 (1-1) (M-2)					
	-				=131	
	tota - totawa - tota					
	73.00		-			

Measured by:	Audited by:	Prototype Approval:	N/A
Date: (2-6-37	Date: 17(do/2)	Date:	N/A

Rev	Date	Change	Revised by	Approyed
Α	06.06.14	New Issue	KJ/JLM A	all

Dart Aerospace Ltd

W/O:	//O:		W	ORK ORDER CHANG	ES					**************************************
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DATE STEP Part No: PAR #: Resolution: NCR: Description of NC	PAR #:	Fault Cate	egory:	_ NCR: Y	es N	o DQ	A:	Date:		
			Disposition: Date: _							
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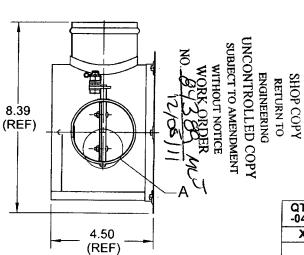


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			744	D3473 SH	EET 1 OF 7					
	DATE		<i>(</i> *	TITLE	SCALE					
	08.12.22			BLOWER INLET ADAPTER	1:4					
	Α΄	0	3.02.07	NEW ISSUE						
	B 06.05.16		6.05.16	D3473-5F/-7F: 9.750 & 8.810 WERE 9.60	& 8.60					
	С			CHG TOL (SHT 3,5-7); 19.520 WAS 19.220; 0.46 WAS 0.38; ADD MFG NOTE (SHT 5,6); MATL						

RELEASED MODELLASED

9.29 (REF)

				SPEC WA	S MIL-S	-5019		
Al MS2466	N960-41	470-9 BOL1 16 WASHEF N310-4 NU1 OTTER PIN	R (4)			D3473-INLET	-043 BLOWE ADAPTER (1	R)
			41 INLET					
		VALVE S	SHAFT (1)	_	!	D3474-041 VALVE SH	INLET AFT (REF)	
WITHOUT WORK O	ENGINEE UNCONTROL	SHOP C			_ <u>'</u>	MS35206-2	217 SCREW WASHER (1) 4 NUT(1)	



D3473-041 BLOWER INLET ADAPTER

NOTES:

- 1) IDENTIFY WITH DART P/N D3473-041 USING FINE POINT PERMANENT INK MARKER 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

	D3474-5 BUTERFLY VALVE (2 PLACES)									
QTY -041	P/N	DESCRIPTION								
Х	D3473-041	BLOWER INLET ADAPTER								
1	D3470-9	BOLT								
1	D3471-043	BLOWER INLET WELDMENT								
1	D3474-041	INLET VALVE SHAFT								
2	D3474-5	BUTTERFLY VALVE								
11	D3474-7	BUTTERFLY VALVE SEAL								
1	AN310-4	NUT								
2	AN960-4L	WASHER								
4	AN960-416	WASHER								
1	MS24665-153	COTTER PIN								
2	MS35206-217	SCREW								
2	NAS679-A04	NUT								

D3474-7 BUTTERFLY VALVE SEAL (1)

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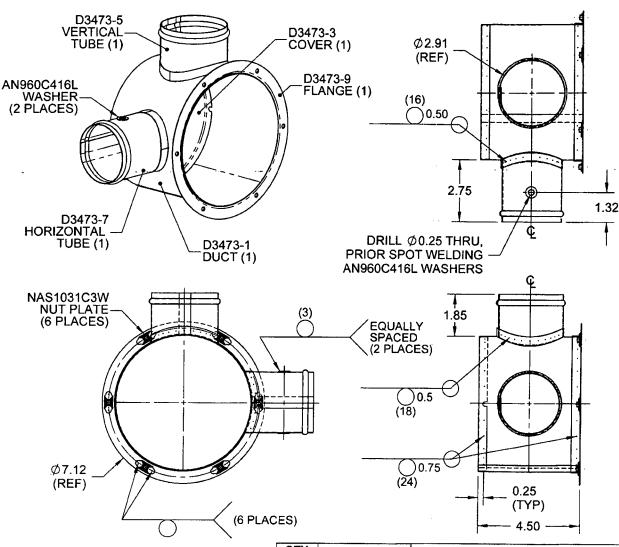
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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector
		PAR #:	Fault Categ	jory:	_ NCR: Yes	_ Date: _			
	R	esolution:	Disposition	: <u>'</u>	_ QA: N/C C	closed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		on B	Verific	cation	Approval	Approval	
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

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D3473-043 BLOWER INLET WELDMENT

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3473-043	BLOWER INLET WELDMENT
1	D3473-1	DUCT
1	D3473-3	COVER
1	D3473-5	VERTICAL TUBE
1	D3473-7	HORIZONTAL TUBE
1	D3473-9	FLANGE
2	AN960C416L	WASHER
6	NAS1031C3W	NUT PLATE

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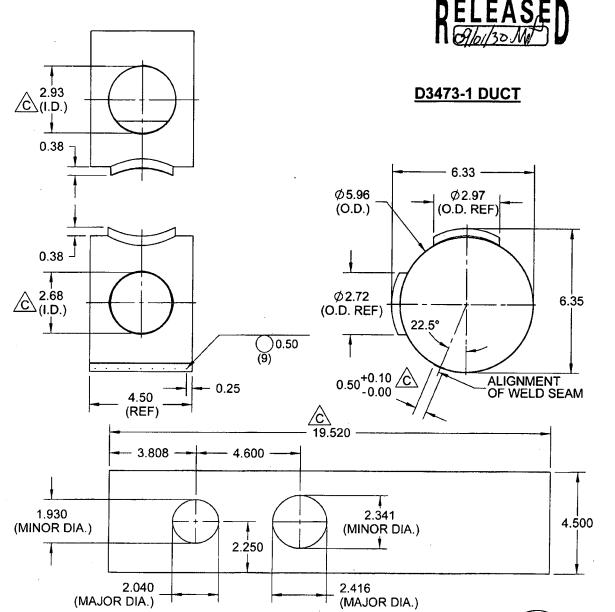
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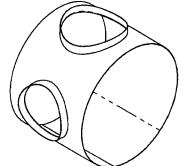


D3473-1F DUCT FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) OR AMS 5513/5524, 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) SPOT WELD PER DART QSI 004
 3) FINISH: NONE

- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES 7) BREAK ALL SHARP EDGES 0.005 TO 0.010



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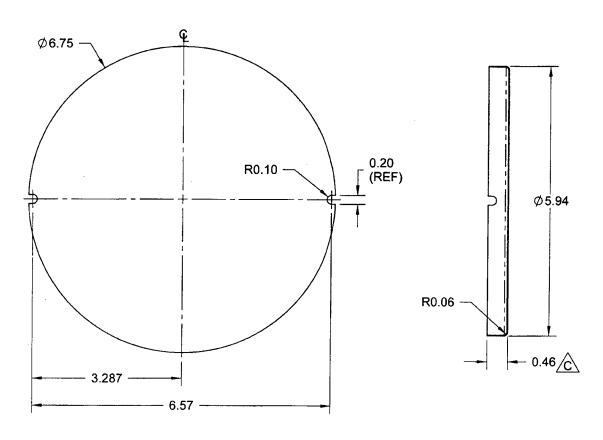
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						NCR: Yes No DQA: Date: QA: N/C Closed: Date:					
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DATE	STEP	Description of NC	Corrective Action Section B				Verification		Approval	Approval	
	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	iption Sign & Date				Chief Eng	QC Inspector	

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DATE 08	3.12.22	BLOWER INLET ADAPTER	SCALE 1:2



D3473-3F COVER FLAT PATTERN

D3473-3 COVER

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) PART IS SYMMETRICAL ABOUT CENTERLINE
 3) FINISH: NONE

- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 5) ALL DIMENSIONS ARE IN INCHES 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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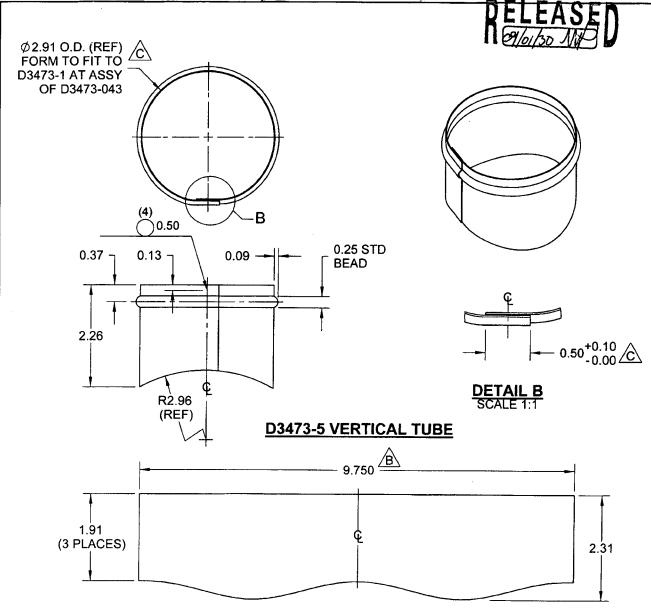
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DATE	CTED	Description of NC Corrective Action			ion B	Verifi	cation	Approval	Approval
DATE	SIEP	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat	N& Sec	Section C	Chief Eng	QC inspector
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DATE	-	TITLE	SCALE
08	.12.22	BLOWER INLET ADAPTER	1:2



D3473-5F VERTICAL TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) SPOT WELD PER DART QSI 004
 3) FINISH: NONE

- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 6) ALL DIMENSIONS ARE IN INCHES
 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

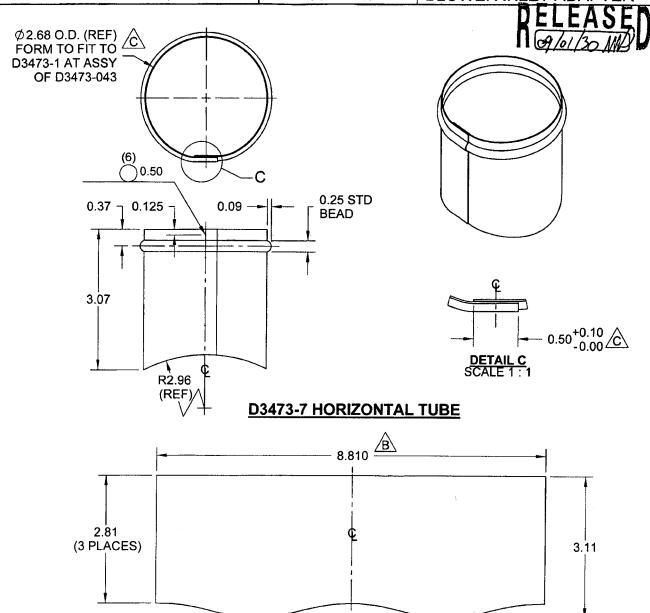
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DATE		TITLE	HEET 6 OF 7 SCALE
08	.12.22	BLOWER INLET ADAPTER	1:2



D3473-7F HORIZONTAL TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) SPOT WELD PER DART QSI 004

- 2) SPOT WELD PER DART QSI 004
 3) FINISH: NONE
 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 6) ALL DIMENSIONS ARE IN INCHES
 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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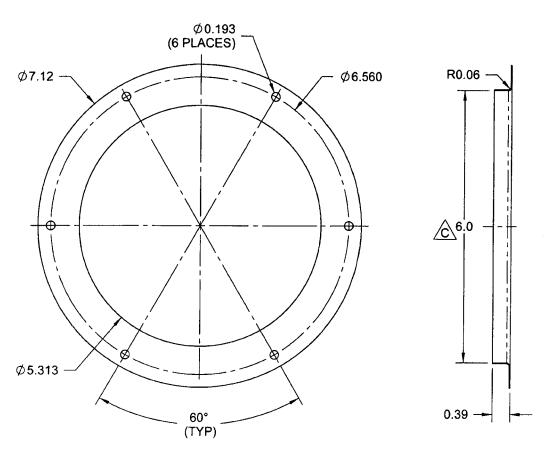
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				Disposition: QA: N/C Closed:							
NCR:		\	WORK ORD	ER NON-CONFORMA	ANCE	(NCR)				
DATE	STED	STEP Description of NC Section A	Corrective Action Section B			Veril		fication	Approval	Approval	
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1 ,	JU.UU. 10		DECAMENTALE ADAPTER 1.2				

RELEASED MAP D



D3473-9F FLANGE FLAT PATTERN

D3473-9 FLANGE BENDING DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No		PAR #:	Fault Cate	gory:	NC	R: Yes	No DQ	A:	Date:			
The state of the s		esolution:	Disposition:									
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DATE	STEP	Description of NC Section A			Section B	Cian 9		rification	Approval	Approval		
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